

Work Order ID 104951

July-23-13 12:57:30 PM

\*104951\*

Page 1

Item ID: D4034-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Aft Upper Rib Assembly

Stop

\*NS2\*

Start Date: 7/23/13 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan: MLC

Date: 13-07-25 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|          |              |  |  |  |  |  |  |  |  |
|----------|--------------|--|--|--|--|--|--|--|--|
| Draw Nbr | Revision Nbr |  |  |  |  |  |  |  |  |
| D4034    | C            |  |  |  |  |  |  |  |  |

100 Weld per dwg A/R S.S. rod Batch: 1123823 0.00

\*100\*

Large Fab

Memo 0.00

(3) 14-10-01

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

\*110\*

QC

Memo 0.00

Quality Control

(3) 13-10-02 DAS 09-89

120

QC5- Inspect part completeness to step on W/O 0.00

\*120\*

QC

Memo 0.00

Quality Control

(3) 13-10-02 DAS 09-89

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: Date:

| Work Order: _____            |  |                |      | DISPOSITION                                |   | AGAINST DEPARTMENT/PROCESS         |  |                                      |              |              |  |
|------------------------------|--|----------------|------|--|---|------------------------------------|--|--------------------------------------|--------------|--------------|--|
|                              |  |                |      | Rework <input type="checkbox"/>            | Skid-tube <input type="checkbox"/>                  | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |              |              |  |
|                              |  |                |      | Scrap <input type="checkbox"/>             | Machining <input type="checkbox"/>                  | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/>    | Quality <input type="checkbox"/>     |              |              |  |
|                              |  |                |      | Use-as-is <input type="checkbox"/>         | Thermoforming <input type="checkbox"/>              | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |              |              |  |
|                              |  |                |      | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/>                  | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/>            |                                      |              |              |  |
| Root Cause                   |  | Date           | Step | Qty  | Description of work order update or Non-conformance | Initial Chief Eng                  | Action Description                           | Sign & Date                          | Verification | QC Inspector |  |
| Doc/Data                     |  |                |      |  |   |                                    |  |                                      |              |              |  |
| Equip/Tooling                |  |                |      |  |   |                                    |  |                                      |              |              |  |
| Operator                     |  |                |      |  |   |                                    |  |                                      |              |              |  |
| Material                     |  |                |      |  |   |                                    |  |                                      |              |              |  |
| Setup                        |  |                |      |  |   |                                    |  |                                      |              |              |  |
| Other                        |  |                |      |  |   |                                    |  |                                      |              |              |  |
| Process                      |  |                |      |  |   |                                    |  |                                      |              |              |  |
| Supplier                     |  |                |      |  |   |                                    |  |                                      |              |              |  |
| Training                     |  |                |      |  |   |                                    |  |                                      |              |              |  |
| Unapproved                   |  |                |      |  |   |                                    |  |                                      |              |              |  |
| FAULT CATEGORY               |  |                |      |  |   |                                    |  |                                      |              |              |  |
| Landing Gear                 |  |                |      | General                                    |   |                                    |  |                                      |              |              |  |
| Bending                      |  | Bend           |      | Grain                                      |   | Ovalized                           |  | Pressure/Forced                      |              |              |  |
| Centre Not Concentric to O/S |  | BOM/Route      |      | Hardware                                   |   | Over/Under tolerance               |  | Temperature/Cure                     |              |              |  |
| Cracks                       |  | Broken/Damaged |      | Inspection Incomplete                      |   | Part Incorrect                     |  | Weld                                 |              |              |  |
| Crushed/Crimped              |  | Burrs          |      | Instructions Incomplete/Unclear            |   | Part Lost/Missing                  |  | Wrong Stock Pulled                   |              |              |  |
| Cuffs                        |  | Contamination  |      | Maintenance                                |   | Part Moved                         |  |                                      |              |              |  |
| Heat Treat                   |  | Countersink    |      | Mislabeled                                 |   | Positioned Wrong                   |  |                                      |              |              |  |
| Inspection Strip in Tube     |  | Cut Too Short  |      | Misread                                    |   | Power Loss/Surge                   |  |                                      |              |              |  |
| Ripples in Bend              |  | Drill Holes    |      | Offset                                     |   |                                    |  |                                      |              |              |  |
| Torque Waves in Extrusion    |  | Drawing        |      | Out of Calibration                         |   |                                    |  |                                      |              |              |  |
| Turning Sequence             |  | Finish         |      | Out of Sequence                            |   |                                    |  |                                      |              |              |  |
| Wave/Twist in Tube           |  | Folio          |      | Outside Dimensions                         |   |                                    |  |                                      |              |              |  |

Work Order ID 104951

\*104951\*

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July-23-13 12:57:30 PM

Item ID: D4034-041

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Aft Upper Rib Assembly

Stop

\*NS2\*

Start Date: 7/23/13 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: *W111*

0.00

3x *CC 13-10-2*

\*130\*

Packaging

Packaging

Memo

0.00

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Quality Control

Memo

0.00

*J/J 13-10-2*

*AB-102*

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: Date:

| Work Order: _____                           |   |   | DISPOSITION  |   |  | AGAINST DEPARTMENT/PROCESS           |             |              |              |  |  |
|---|---|---|--|---|--|--------------------------------------|-------------|--------------|--------------|--|--|
| Part No. _____                              | Rework <input type="checkbox"/>                       | Scrap <input type="checkbox"/>              | Skid-tube <input type="checkbox"/>                       | Crosstube <input type="checkbox"/>                  | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |             |              |              |  |  |
| NCR No. _____                               | Use-as-is <input type="checkbox"/>                    | Thermoforming <input type="checkbox"/>      | Machining <input type="checkbox"/>                       | Small Fab <input type="checkbox"/>                  | Prod. Eng. Coor. <input type="checkbox"/>    | Quality <input type="checkbox"/>     |             |              |              |  |  |
|   | Work Order Update <input type="checkbox"/>            |   | Large Fab <input type="checkbox"/>                       | Finishing <input type="checkbox"/>                  | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |             |              |              |  |  |
|   |   |   |  | Composite <input type="checkbox"/>                  | Supplier <input type="checkbox"/>            |                                      |             |              |              |  |  |
| Root Cause                                  | Date  | Step  | Qty  | Description of work order update or Non-conformance | Initial Chief Eng                            | Action Description                   | Sign & Date | Verification | QC Inspector |  |  |
| Doc/Data                                    |   |   |  |   |  |                                      |             |              |              |  |  |
| Equip/Tooling                               |   |   |  |   |  |                                      |             |              |              |  |  |
| Operator                                    |   |   |  |   |  |                                      |             |              |              |  |  |
| Material                                    |   |   |  |   |  |                                      |             |              |              |  |  |
| Setup                                       |   |   |  |   |  |                                      |             |              |              |  |  |
| Other                                       |   |   |  |   |  |                                      |             |              |              |  |  |
| Process                                     |   |   |  |   |  |                                      |             |              |              |  |  |
| Supplier                                    |   |   |  |   |  |                                      |             |              |              |  |  |
| Training                                    |   |   |  |   |  |                                      |             |              |              |  |  |
| Unapproved                                  |   |   |  |   |  |                                      |             |              |              |  |  |
| FAULT CATEGORY                              |   |   |  |   |  |                                      |             |              |              |  |  |
| Landing Gear                                | General   |   |  |   |  |                                      |             |              |              |  |  |
|   | Bending <input type="checkbox"/>                      | Bend <input type="checkbox"/>               | Grain <input type="checkbox"/>                           | Ovalized <input type="checkbox"/>                   | Pressure/Forced <input type="checkbox"/>     |                                      |             |              |              |  |  |
|   | Centre Not Concentric to O/S <input type="checkbox"/> | BOM/Route <input type="checkbox"/>          | Hardware <input type="checkbox"/>                        | Over/Under tolerance <input type="checkbox"/>       | Temperature/Cure <input type="checkbox"/>    |                                      |             |              |              |  |  |
|   | Cracks <input type="checkbox"/>                       | Broken/Damaged <input type="checkbox"/>     | Inspection Incomplete <input type="checkbox"/>           | Part Incorrect <input type="checkbox"/>             | Weld <input type="checkbox"/>                |                                      |             |              |              |  |  |
|   | Crushed/Crimped <input type="checkbox"/>              | Burrs <input type="checkbox"/>              | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/>          | Wrong Stock Pulled <input type="checkbox"/>  |                                      |             |              |              |  |  |
|   | Cuffs <input type="checkbox"/>                        | Contamination <input type="checkbox"/>      | Maintenance <input type="checkbox"/>                     | Part Moved <input type="checkbox"/>                 |  |                                      |             |              |              |  |  |
|   | Heat Treat <input type="checkbox"/>                   | Countersink <input type="checkbox"/>        | Mislabeled <input type="checkbox"/>                      | Positioned Wrong <input type="checkbox"/>           |  |                                      |             |              |              |  |  |
|   | Inspection Strip in Tube <input type="checkbox"/>     | Cut Too Short <input type="checkbox"/>      | Misread <input type="checkbox"/>                         | Power Loss/Surge <input type="checkbox"/>           | Other <input type="checkbox"/>               |                                      |             |              |              |  |  |
|   | Ripples in Bend <input type="checkbox"/>              | Drill Holes <input type="checkbox"/>        | Offset <input type="checkbox"/>                          |   |  |                                      |             |              |              |  |  |
|   | Torque Waves in Extrusion <input type="checkbox"/>    | Drawing <input type="checkbox"/>            | Out of Calibration <input type="checkbox"/>              |   |  |                                      |             |              |              |  |  |
| Turning Sequence <input type="checkbox"/>   | Finish <input type="checkbox"/>                       | Out of Sequence <input type="checkbox"/>    |  |   |  |                                      |             |              |              |  |  |
| Wave/Twist in Tube <input type="checkbox"/> | Folio <input type="checkbox"/>                        | Outside Dimensions <input type="checkbox"/> |  |   |  |                                      |             |              |              |  |  |

# Picklist Print

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Page 1

**Work Order ID:** 104951

**Parent Item:** D4034-041

**Start Date:** 7/23/13

**Required Date:** 7/23/13

**Parent Item Name:** Aft Upper Rib Assembly

**Start Qty:** 2.00

**Required Qty:** 2.00

**Comments:** IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA 10.03.15  
verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP  
Rev:D 13.03.14 AS PER DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C  
DD VERF:JFS

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit     | Total<br>Qty   | Qty<br>Issued | Date<br>Issued | Status              |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|----------------|---------------|----------------|---------------------|
| D4034-1<br>Rib                  |                        | Manufactured  | No          |                     |                  | 100             | Each               | 4.0000         | 1               | <i>B104371</i> | <i>2</i>      | <i>3x</i>      |                     |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    |                | <u>Loc Code</u> |                |               |                | <i>SLY 13.09.26</i> |
|                                 |                        |               |             | WA004               |                  | 4               |                    |                |                 |                |               |                |                     |
|                                 |                        |               |             | 101056              |                  | 1               |                    |                |                 |                |               |                |                     |
|                                 |                        |               |             | 83755               |                  | 1               |                    |                |                 |                |               |                |                     |
|                                 |                        |               |             | 89359               |                  | 1               |                    |                |                 |                |               |                |                     |
|                                 |                        |               |             | 97591               |                  | 1               |                    |                |                 |                |               |                |                     |
| D4034-3<br>Rib                  |                        | Manufactured  | No          |                     |                  | 100             | Each               | 7.0000         | 1               | <i>B104604</i> | <i>2</i>      | <i>3x</i>      |                     |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    |                | <u>Loc Code</u> |                |               |                | <i>SLY 13.09.26</i> |
|                                 |                        |               |             | WA                  |                  | 4               |                    |                |                 |                |               |                |                     |
|                                 |                        |               |             | 101013              |                  | 4               |                    |                |                 |                |               |                |                     |
|                                 |                        |               |             | WA004               |                  | 1               |                    |                |                 |                |               |                |                     |
|                                 |                        |               |             | 101014              |                  | 1               |                    |                |                 |                |               |                |                     |
|                                 |                        |               |             | WA005               |                  | 2               |                    |                |                 |                |               |                |                     |
|                                 |                        |               |             | 94179               |                  | 2               |                    |                |                 |                |               |                |                     |
| D4021-7<br>Hoop                 |                        | Manufactured  | No          |                     |                  | 100             | Each               | 23.0000        | 1               | <i>B105882</i> | <i>2</i>      | <i>3x</i>      |                     |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    |                | <u>Loc Code</u> |                |               |                | <i>SLY 13.09.26</i> |
|                                 |                        |               |             | WA004               |                  | 23              |                    |                |                 |                |               |                |                     |
|                                 |                        |               |             | 100432              |                  | 2               |                    |                |                 |                |               |                |                     |
|                                 |                        |               |             | 103582              |                  | 18              |                    |                |                 |                |               |                |                     |
|                                 |                        |               |             | 88428               |                  | 3               |                    |                |                 |                |               |                |                     |

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: Date:

| Work Order: _____ |      |      | DISPOSITION                                   |   |  | AGAINST DEPARTMENT/PROCESS            |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
|-------------------|------|------|---|---|--|---------------------------------------|---|---|--|--|---|---|--|--|--|---|--|---|---|---|---|---|-------------------------------------|------------------------------------|-----------------------------------|-----------------------------------|--------------------------------------|---|---|---|--|-------------------------------------|------------------------------------|--|---|--|--------------------------------------|--|--|---|--|--|--|---|
|                   |      |      | Rework<br><input type="checkbox"/>            | Scrap<br><input type="checkbox"/>                   | Use-as-is<br><input type="checkbox"/>                    | Skid-tube<br><input type="checkbox"/> | Machining<br><input type="checkbox"/>       | Thermoforming<br><input type="checkbox"/> | Large Fab<br><input type="checkbox"/>  | Crosstube<br><input type="checkbox"/>                | Small Fab<br><input type="checkbox"/>       | Finishing<br><input type="checkbox"/>                 | Composite<br><input type="checkbox"/>        | Water Jet<br><input type="checkbox"/>          | Prod. Eng. Coor.<br><input type="checkbox"/> | Rec/Store/Packaging<br><input type="checkbox"/> | Supplier<br><input type="checkbox"/>       | Engineering<br><input type="checkbox"/> | Quality<br><input type="checkbox"/>       | Other<br><input type="checkbox"/>       |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Part No. _____    |      |      | Work Order Update<br><input type="checkbox"/> |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| NCR No. _____     |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Root Cause        | Date | Step | Qty   | Description of work order update or Non-conformance |  | Initial Chief Eng                     | Action Description                          |   |  | Sign & Date  | Verification                                |   | QC Inspector                                 |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Doc/Data          |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Equip/Tooling     |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Operator          |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Material          |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Setup             |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Other             |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Process           |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Supplier          |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Training          |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Unapproved        |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| FAULT CATEGORY    |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Landing Gear      |      |      |   | General   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
|                   |      |      |   | Bending<br><input type="checkbox"/>                 | Centre Not Concentric to O/S<br><input type="checkbox"/> | Cracks<br><input type="checkbox"/>    | Crushed/Crimped<br><input type="checkbox"/> | Cuffs<br><input type="checkbox"/>         | Heat Treat<br><input type="checkbox"/> | Inspection Strip in Tube<br><input type="checkbox"/> | Ripples in Bend<br><input type="checkbox"/> | Torque Waves in Extrusion<br><input type="checkbox"/> | Turning Sequence<br><input type="checkbox"/> | Wave/Twist in Tube<br><input type="checkbox"/> | Bend<br><input type="checkbox"/>             | BOM/Route<br><input type="checkbox"/>           | Broken/Damaged<br><input type="checkbox"/> | Burrs<br><input type="checkbox"/>       | Contamination<br><input type="checkbox"/> | Countersink<br><input type="checkbox"/> | Cut Too Short<br><input type="checkbox"/> | Drill Holes<br><input type="checkbox"/> | Drawing<br><input type="checkbox"/> | Finish<br><input type="checkbox"/> | Folio<br><input type="checkbox"/> | Grain<br><input type="checkbox"/> | Hardware<br><input type="checkbox"/> | Inspection Incomplete<br><input type="checkbox"/> | Instructions Incomplete/Unclear<br><input type="checkbox"/> | Maintenance<br><input type="checkbox"/> | Mislabeled<br><input type="checkbox"/> | Misread<br><input type="checkbox"/> | Offset<br><input type="checkbox"/> | Out of Calibration<br><input type="checkbox"/> | Out of Sequence<br><input type="checkbox"/> | Outside Dimensions<br><input type="checkbox"/> | Ovalized<br><input type="checkbox"/> | Over/Under tolerance<br><input type="checkbox"/> | Part Incorrect<br><input type="checkbox"/> | Part Lost/Missing<br><input type="checkbox"/> | Part Moved<br><input type="checkbox"/> | Positioned Wrong<br><input type="checkbox"/> | Power Loss/Surge<br><input type="checkbox"/> | Pressure/Forced<br><input type="checkbox"/> |

# Picklist Print

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Work Order ID: 104951

Parent Item: D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 7/23/13

Required Date: 7/23/13

Start Qty: 2.00

Required Qty: 2.00

D4021-9  
Bushing

Manufactured No

100 Each 287.0000

<sup>4</sup>  
B102664-12x

Sy 13.09.26

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA       | 36      |          |
| 103746   | 36      |          |
| WA002    | 6       |          |
| 102482   | 4       |          |
| 99143    | 2       |          |
| WA004    | 245     |          |
| 100402   | 55      |          |
| 100917   | 40      |          |
| 102664   | 80      |          |
| 103548   | 10      |          |
| 66437    | 2       |          |
| 70333    | 4       |          |
| 72482    | 4       |          |
| 82977    | 1       |          |
| 84717    | 3       |          |
| 88077    | 23      |          |
| 88377    | 7       |          |
| 92020    | 12      |          |
| 98877    | 4       |          |

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

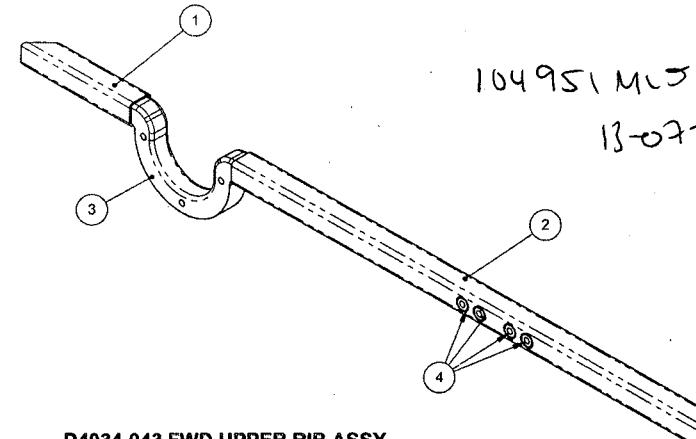
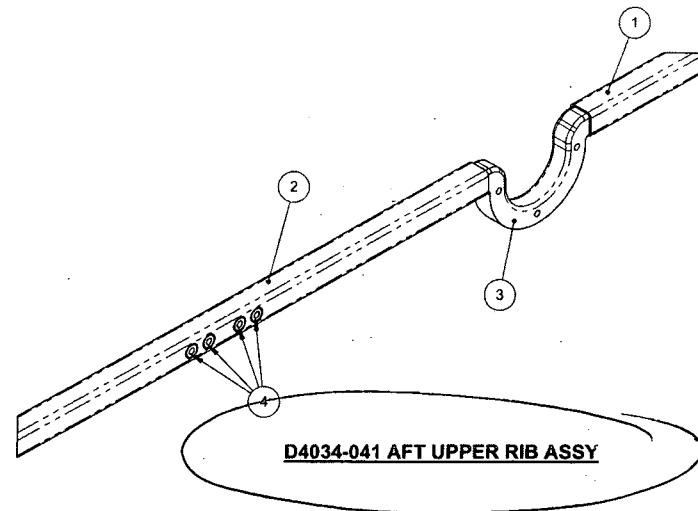
**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| Work Order: _____ |      |      | DISPOSITION                                   |   |  | AGAINST DEPARTMENT/PROCESS            |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
|-------------------|------|------|---|---|--|---------------------------------------|---|---|--|--|---|---|--|--|--|---|--|---|---|---|---|---|-------------------------------------|------------------------------------|-----------------------------------|-----------------------------------|--------------------------------------|---|---|---|--|-------------------------------------|------------------------------------|--|---|--|--------------------------------------|--|--|---|--|--|--|---|
|                   |      |      | Rework<br><input type="checkbox"/>            | Scrap<br><input type="checkbox"/>                   | Use-as-is<br><input type="checkbox"/>                    | Skid-tube<br><input type="checkbox"/> | Machining<br><input type="checkbox"/>       | Thermoforming<br><input type="checkbox"/> | Large Fab<br><input type="checkbox"/>  | Crosstube<br><input type="checkbox"/>                | Small Fab<br><input type="checkbox"/>       | Finishing<br><input type="checkbox"/>                 | Composite<br><input type="checkbox"/>        | Water Jet<br><input type="checkbox"/>          | Prod. Eng. Coor.<br><input type="checkbox"/> | Rec/Store/Packaging<br><input type="checkbox"/> | Supplier<br><input type="checkbox"/>       | Engineering<br><input type="checkbox"/> | Quality<br><input type="checkbox"/>       | Other<br><input type="checkbox"/>       |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Part No. _____    |      |      | Work Order Update<br><input type="checkbox"/> |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| NCR No. _____     |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Root Cause        | Date | Step | Qty   | Description of work order update or Non-conformance |  | Initial Chief Eng                     | Action Description                          |   |  | Sign & Date  | Verification                                |   | QC Inspector                                 |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Doc/Data          |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Equip/Tooling     |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Operator          |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Material          |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Setup             |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Other             |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Process           |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Supplier          |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Training          |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Unapproved        |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| FAULT CATEGORY    |      |      |   |   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
| Landing Gear      |      |      |   | General   |  |                                       |   |   |  |  |   |   |  |  |  |   |  |   |   |   |   |   |                                     |                                    |                                   |                                   |                                      |   |   |   |  |                                     |                                    |  |   |  |                                      |  |  |   |  |  |  |   |
|                   |      |      |   | Bending<br><input type="checkbox"/>                 | Centre Not Concentric to O/S<br><input type="checkbox"/> | Cracks<br><input type="checkbox"/>    | Crushed/Crimped<br><input type="checkbox"/> | Cuffs<br><input type="checkbox"/>         | Heat Treat<br><input type="checkbox"/> | Inspection Strip in Tube<br><input type="checkbox"/> | Ripples in Bend<br><input type="checkbox"/> | Torque Waves in Extrusion<br><input type="checkbox"/> | Turning Sequence<br><input type="checkbox"/> | Wave/Twist in Tube<br><input type="checkbox"/> | Bend<br><input type="checkbox"/>             | BOM/Route<br><input type="checkbox"/>           | Broken/Damaged<br><input type="checkbox"/> | Burrs<br><input type="checkbox"/>       | Contamination<br><input type="checkbox"/> | Countersink<br><input type="checkbox"/> | Cut Too Short<br><input type="checkbox"/> | Drill Holes<br><input type="checkbox"/> | Drawing<br><input type="checkbox"/> | Finish<br><input type="checkbox"/> | Folio<br><input type="checkbox"/> | Grain<br><input type="checkbox"/> | Hardware<br><input type="checkbox"/> | Inspection Incomplete<br><input type="checkbox"/> | Instructions Incomplete/Unclear<br><input type="checkbox"/> | Maintenance<br><input type="checkbox"/> | Mislabeled<br><input type="checkbox"/> | Misread<br><input type="checkbox"/> | Offset<br><input type="checkbox"/> | Out of Calibration<br><input type="checkbox"/> | Out of Sequence<br><input type="checkbox"/> | Outside Dimensions<br><input type="checkbox"/> | Ovalized<br><input type="checkbox"/> | Over/Under tolerance<br><input type="checkbox"/> | Part Incorrect<br><input type="checkbox"/> | Part Lost/Missing<br><input type="checkbox"/> | Part Moved<br><input type="checkbox"/> | Positioned Wrong<br><input type="checkbox"/> | Power Loss/Surge<br><input type="checkbox"/> | Pressure/Forced<br><input type="checkbox"/> |

|      |           |   |         |                    |
|------|-----------|---|---------|--------------------|
| ITEM | Q1        | 4 | DE      | 04                 |
| X    | D4034-041 |   |         | AFT UPPER RIB ASSY |
| X    | D4034-043 |   |         | FWD UPPER RIB ASSY |
| 1    | 1         | 1 | D4034-1 | RIB                |
| 2    | 1         | 1 | D4034-3 | RIB                |
| 3    | 1         | 1 | D4021-7 | HOOP               |
| 4    | 4         | 4 | D4021-9 | BUSHING            |

C

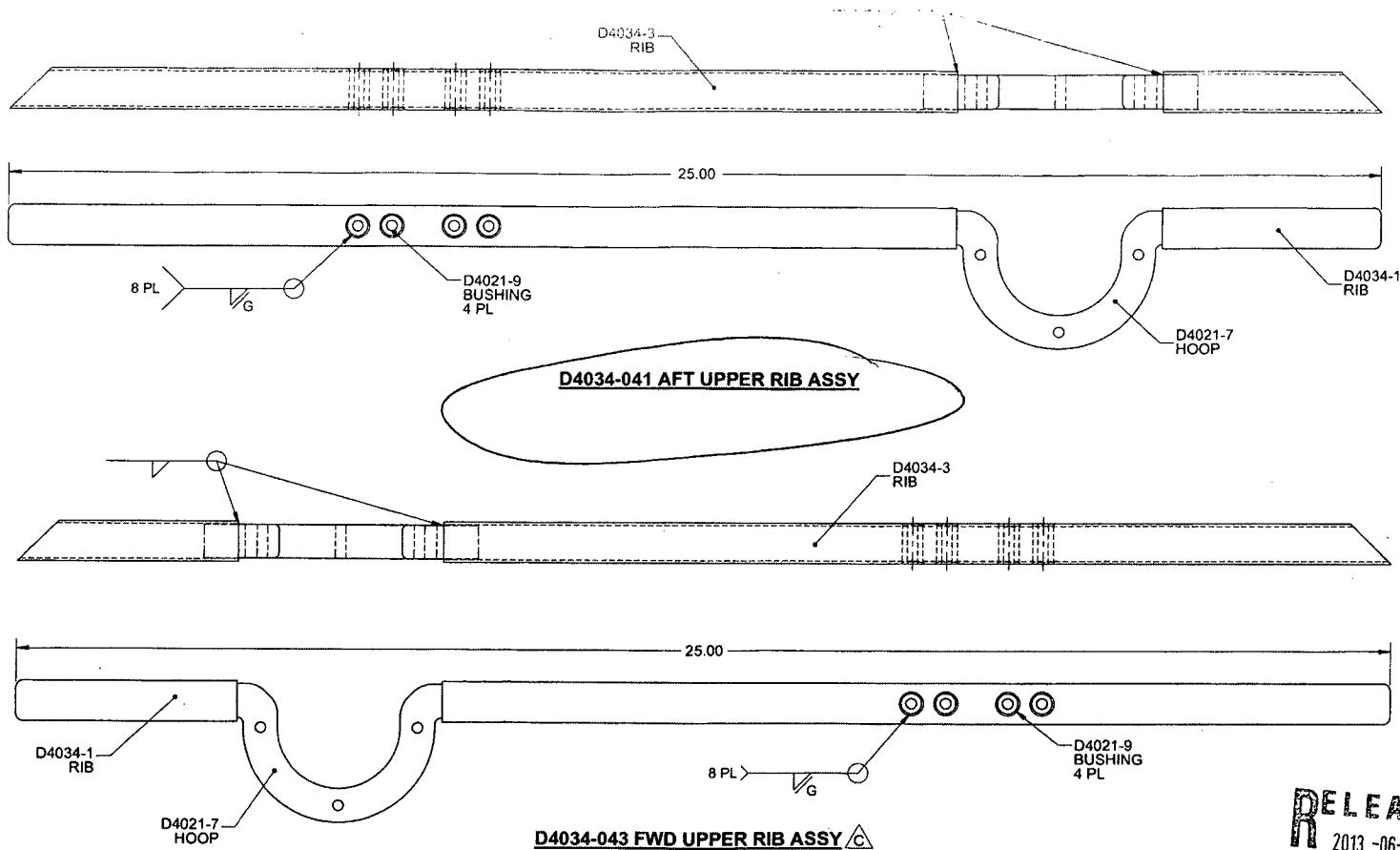


RELEASED  
2013-06-20  
AM

|            |  |  |              |
|------------|--|--|--------------|
| C          | 043 REDESIGNED AS MIRROR IMAGE OF -041. -5<br>DELETED. -5 DELETED. REASON PROP ARM NO<br>LONGER OFFERED. | AJS  | 13.03.13     |
| B          | ADDITIONAL HOLES ADDED ON D4034-3 RIB  | SC   | 10.12.20     |
| A          | NEW ISSUE  | AJS  | 10.03.04     |
| REV.       | DESCRIPTION  | BY   | DATE         |
| DESIGN     | AJS  | DART AEROSPACE LTD   |              |
| DRAWN      | AJS  | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | A.P.   | DRAWING NO.  | REV. C       |
| MFG. APPR. | IV   | D4034  | SHEET 1 OF 3 |
| APPROVED   | AP   | TITLE  | SCALE        |
| DE APPR.   | -  | UPPER RIB ASSY, BASKET BASE  | NTS          |
| DATE       | 13.03.13   | COPYRIGHT © 2010 BY DART AEROSPACE LTD.<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY OTHER PURPOSE THAN THAT FOR WHICH IT WAS PROVIDED.<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

8 7 6 5 4 3 2 1

104951



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

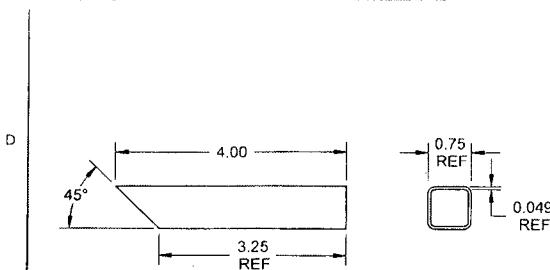
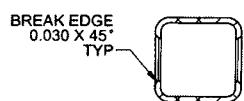
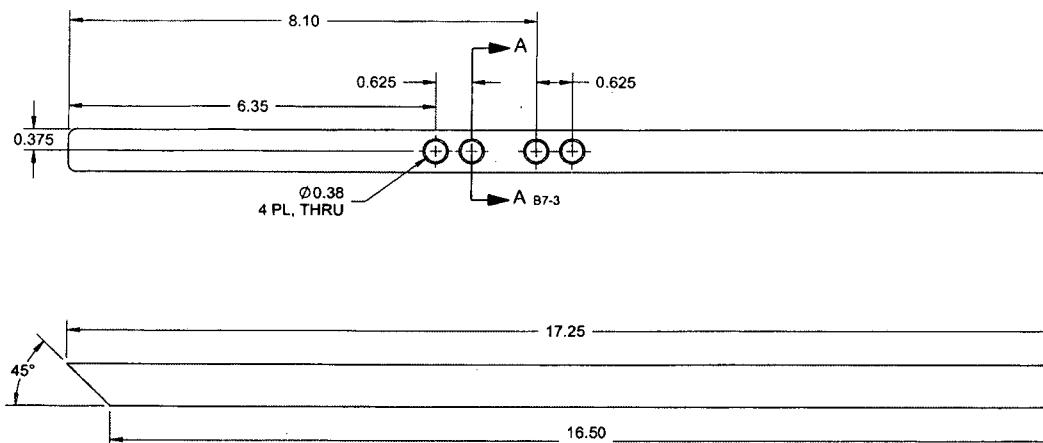
8 1 7 6 5 4 3 2 1

|            |          |                                 |  |
|------------|----------|---------------------------------|--|
| DESIGN     | AJS      | <b>DART AEROSPACE LTD</b>       |  |
| DRAWN      | AJS      | HAWKESBURY, ONTARIO, CANADA     |  |
| CHECKED    | AJ       | REV. C                          |  |
| MFG. APPR. | DA       | DRAWING NO. D4034               |  |
| APPROVED   | MP       | SHEET 2 OF 3                    |  |
| DE APPR.   | MP       | TITLE                           |  |
| DATE       | 13.03.13 | SCALE                           |  |
|            |          | UPPER RIB ASSY, BASKET BASE NTS |  |

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RELEASED  
2013-06-20  
MP

104957

**D4034-1 RIB****SECTION A-A C3-3****D4034-3 RIB**

**RELEASED**  
2013-06-28  
*M*

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs  
-3: 0.62 lbs

8            7            6            5            4            3            2            1

|            |           |  |
|------------|-----------|--|
| DESIGN     | AJS       | <b>DART AEROSPACE LTD</b>  |
| DRAWN      | AJS       | HAWKESBURY, ONTARIO, CANADA  |
| CHECKED    | <i>AP</i> | DRAWING NO.  |
| MFG. APPR. | <i>DS</i> | REV. C   |
| APPROVED   | <i>AP</i> | D4034  |
| DE APPR.   | <i>AP</i> | SHEET 3 OF 3   |
| DATE       | 13.03.13  | TITLE  |
|            |           | SCALE  |
|            |           | NTS  |
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